

Date: Tuesday, 12/20/2005 9:44:55 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206B BASKET BASE		
Job Number	: 22087B		Part Number	: D2330041		
Estimate Number	: 11276		Drawing Number	: UNDER REVIEW		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 12/20/2005	S.O. No. : N/A	Drawing Revision	: E		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 1/30/2006 Qty: 1 Um: Each		
Previous Run	:					
Written By	: SEE COMMENT BELOW					
Checked & Approved By	: SEE ABOVE USER & DATE					
Comment	: Est Rev:H 02.09.04 M304EX0.75-16F was M750-16FXS-S/S K J					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :				
1.0	D31661	Basket Hoop				
Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: 4 Qty Part# Description Batch 4 D3166-1 Hoop B0b2S9 (2) B25849 (2) PD 06-04-05						
2.0	M304TS0750W065	304 SQ Tube.75x.75x.065W				
Comment: Qty.: 25.3019 f(s)/Unit Total : 25.3019 f(s) 3/4" x 3/4" x 0.063 wall 304/316 SS tubing. Batch: M100S60 PD 06-04-05						
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1				
Comment: LARGE FABRICATION RESOURCE 1 1-Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing. Cut 4 D2235-1 From D3166-1 2- Cut D2330-1-3-5-7-9 as per Dwg D2330 3-Drill hole in D2330-3 as per Dwg D2330						
4-Deburr						PD 06-04-05
4.0	D22531	Lug				
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 D2253 Gusset B12413						
						PD 06-04-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 9:44:56 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET BASE

Job Number: 22087B

Part Number: D2330041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D2012107

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2012-107	Clevis	<u>6-26-05 B25483</u>

PD

06-04-05

6.0 D23273

Spacer Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2327-3	Bushing	<u>B25483</u>

PD

06-04-05

7.0 D2581

Mounting Bracket



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	D2581	Mounting Chanel	<u>B25814(3) B26204 (1)</u>

PD

06-04-05

8.0 D2254

Gusset for D206bskt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2254	Lug	<u>B23421</u>

PD

06-04-05

9.0 D22323

Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2232-3	HINGE	<u>B25239</u>

PD

06-04-05

10.0 D2012107

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2012-107	CLEVIS	<u>6-26-05 B25483</u>

PD

06-04-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/04/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 9:44:56 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET BASE

Job Number: 22087B

Part Number: D2330041

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 M304EX07516F Expanded Metal Flat Stai



Comment: Qty.: 31.5000 sf(s)/Unit Total : 31.5000 sf(s)

Pick:

Qty Part Number Description Batch

30 sf M304EX0.75-16F Expanded Metal M100513

PD

06-04-11

12.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2330 using Welding Table and corner JigDeburr as required

A/R SS ROD Batch: M19555

PD

06-04-11

13.0 QC5/9 WELD INSPECTION



Comment: WELD INSPECTION

1A 06/04/11

14.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DC 06/04/13 ①

15.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 09 13 ①

16.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

W/A W

17.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

① 06/04/20

Job Completion



✓ 06-04-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5/04

DART AEROSPACE LTD		Work Order:	22087
Description: 206B Basket Base		Part Number:	D2330-041
D1 Drawing: D2330 Rev. D Pages 1,3,4 & 5		Qty:	1

P04.0L23

Step	Location	Procedure	By	Date	Qty
1	DC	Open Traveller Dwg not required	RF	04.12.14	1
2	WS	Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing. Batch: _____ Cut Qty. 4 D2235-1 from: Qty. 4 D3166-1 Batch: _____			
3	WS	Drill hole in D2330-3 as per Dwg D2330			
4	WS	Deburr			
5	WS RF 02/09/13	Pick: Qty Part Number Description Batch 2 D2253-1 Gusset 1 D2012-107 Clevis 1 D2327-3 Bushing 4 D2581 Mounting Chanel 2 D2254 Lug 30 sf M304EX0.75-16F Expanded Metal			
6	WS	Weld as per Dwg D2330 using Welding Table and corner Jig Deburr as required			
7	QC9 & 6	Inspect Welding and Dimensions			
8	WS	Take Traveller D206-540-013 to KP			
9	FP	Powder Coat White (Ref. 4.3.5.2) as per QSI 005 4.3			
10	QC3	Inspect Powder Coat			
11	FP	To Miscellaneous Cell for Assembly			

Rev	Date	Change	Revised By	Approved
B	94.12.03	/		JB
C	99.09.17	Re-format (was Ipp-341B)	EC	
D	99.12.14	Re-format, Added Clevis to pick list	EC	
E	00.02.03	Re-format, Added Rib to pick list	EC	
F	00.06.26	Removed P/O for powder coat	EC	
G	02.07.23	Re-format added D3166-1; Modify Step 1	KJ	
H	02.09.04	M304EX0.75-16F was M750-16FXS-S/S	KJ RF	RF

RELEASED
02/09/09 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____